

Work Order ID 71065

Tuesday, June 21, 2011 1:44:17 PM

BLUE

Must ship 29/06
Accept



ilgaly

Item ID: D2932-1

Revision ID:

Item Name: Saddle LH Out, 206

Start Date: 6/21/2011 Start Qty: 2.00

Required Date: 6/29/2011 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2932	Rev C								

100 0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

SL 11/06/28 ②

110 0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11/06/28

2 ϕ

120 0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

SL 11/06/28

2 ϕ

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Item ID: D2932-1

Accept



Setup Start



Revision ID:

Item Name: Saddle LH Out, 206

Stop



Start Date: 6/21/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



B-A 11/06/28

2

4

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



2 BR 11-6-28.

HandFinish

Memo

0.00

Hand Finishing

155

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B 117319
DELFLEET BLUE B 115985
DELFLEET CLEAR B 117113

M 11 06 28 (2)

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Item ID: D2932-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 6/21/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

8 11 - 06 - 29 (2)

170

Identify as per dwg & Stock Location: S+421

0.00



Packaging

Memo

0.00

Packaging

E fb (2) 11/06/29

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/30 JF
11-06-29

Picklist Print

Tuesday, June 21, 2011 1:44:14 PM

Page 1

Work Order ID: 71065



Parent Item: D2932-1



Parent Item Name: Saddle LH Out, 206

Start Date: 6/21/2011

Required Date: 6/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B100.06.26 New DWG rev, (mpp 2069) E C
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	31.0000	1	2		11/06/28	

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT	5	
69701	5	
MAT040	20	
69678	20	
MAT45	6	
68172	6	

66964

2

not in computer

DART AEROSPACE LTD	Work Order: <i>7165</i>
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

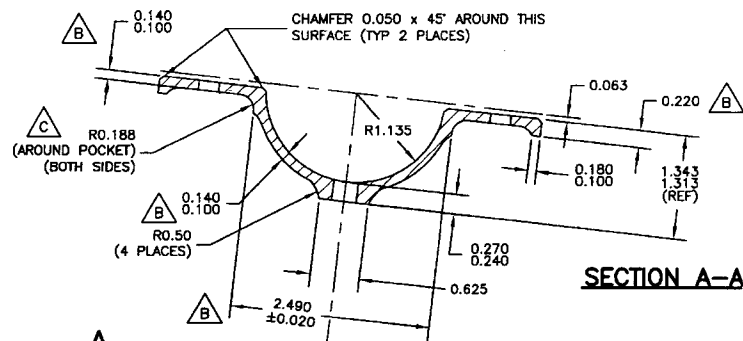
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.123				
B	0.100	0.140		.119	.125				
C	0.100	0.140		.112	.121				
D	0.210	0.230		.213	.223				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.513	.513				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.257	.257				
L	0.312	0.317		.3163B	.3163B				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.111	.120				
O	0.540	0.560		.550	.546				
P	0.490	0.510		.500	.499				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		.247	.256				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.132	1.133				
Y	1.565	1.585		1.571	1.572				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

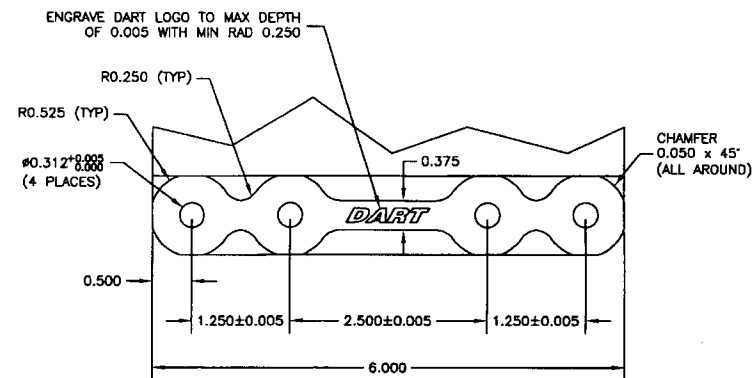
Measured by: <i>SL</i>
Date: <i>11/06/27</i>

Audited by: <i>B.A</i>
Date: <i>11/06/28</i>

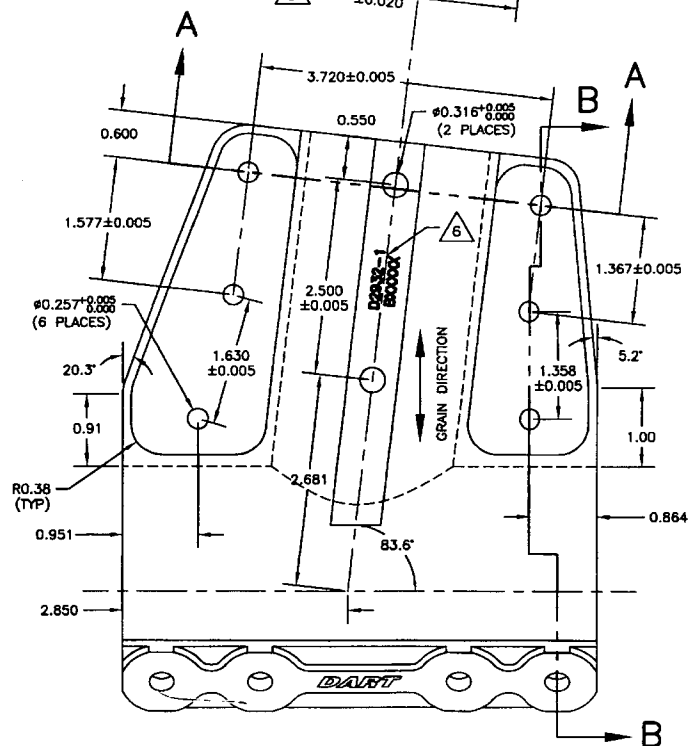
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



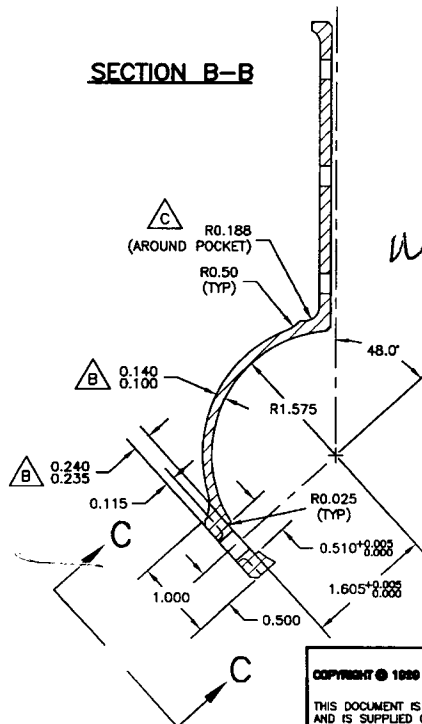
SECTION A-A



VIEW C-C



SECTION B-B



D2932-1 LH SADDLE (SHOWN)

D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (00-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C D2932 SHEET 1 OF 1 SCALE 2:3

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BELLEVUE, WA

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07-02-02